

Wednesday, 2/20/2008 4:21:09 PM

Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	R/H LOW PROFILE BASKET BASE ASS'Y		
Job Number	37525			Part Number	D3712042		
Estimate Number	13171			Drawing Number	D3712 U/R		
P.O. Number				Project Number	N/A		
This Issue	2/20/2008	S.O. No.		Drawing Revision	U/R		
Prsht Rev.	NC			Material			
First Issue	/ /	Type	LARGE FAB ASSY	Due Date	3/10/2008		
Previous Run	37524			Qty:	1 Um: Each		
Written By				Comment			
Checked & Approved By				Est Rev:A	new issue	08-01-30	DD verified by:EC

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304TS0750W065	304 SQ Tube.75x.75x.065W
Comment: Qty.: 44.7920 f(s)/Unit Total : 44.7920 f(s)		
304 SQ Tube.75x.75x.065W		
1- Cut Ribs as per dwg from 3/4" x 3/4" x 0.065 wall 304/316 SS tubing.		
QTY	PART NUMBER	BATCH
2	D3726-1	<u>M107038</u>
2	D3727-1	<u>M107038</u>
2	D3734-1	<u>M107038</u>
6	D3735-1	<u>M107038</u>
3	D3739-1	<u>M107038</u>
3	D3740-1	<u>M107038</u>
ASS	21 D3759-1	<u>B371063</u>
2- deburr		
2.0	D23273	Spacer Bushing
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)		
Spacer Bushing batch <u>336479</u>		
3.0	D2581	Mounting Bracket
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)		
Mounting Bracket batch <u>B36481</u>		

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 2/20/2008 4:21:09 PM
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Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

D37251

HOOP



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

HOOP

batch B37127

pl 08-02-27

5.0

D37481

HINGE HALF



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

HINGE HALF

batch B37305

pl 08-02-27

6.0

D31661

Basket Hoop



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Basket Hoop

Batch: B36752

pl 08/02/25

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

pl 08/02/25

1- take D3166-1 and trim as per dwg D3746 to make D3746-1

2- take D3746-1 and drill holes as per dwg D3646

3- drill holes in both D3727-1 as per dwg D3727

4- take 1x D3735-1 and drill holes as per dwg D3735

5- deburr

6- assemble as per dwg D3712 and weld as per QSI004

pl 08-02-27

8.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

pl 08-02-27

W/O:		WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

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Job Number: 37525

Part Number: D3712042

Job Number:



Seq. #: Machine Or Operation:

Description :

9.0 QC5

INSPECT WORK TO CURRENT STEP

AS
08.02.27



Comment: INSPECT WORK TO CURRENT STEP

10.0 M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 39.9000 sf(s)/Unit Total : 39.9000 sf(s)

Expanded Metal Flat Stainless Steel

Pick:

Qty	Part Number	Description	Batch
38sq.ft	M304EX0.75-16F	Expanded Metal	M106884

FF 08.02.27

11.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- cut mesh to fit inside basket base and sides as per dwg D

2- weld mesh as per dwg D3712

12.0 QC5

INSPECT WORK TO CURRENT STEP

ENGINEERING

APPROVAL

FF 08.02.27
FF 08.03.03

Comment: INSPECT WORK TO CURRENT STEP

13.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08.03.07 (1)

14.0 POWDER COATING

POWDER COATING



M102005

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

FD 08/03/10 (1)

15.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FF 08-03-12 (1)

16.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

FF 08-03-02 (1)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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Job Number:



Seq. #: Machine Or Operation:

Description :

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



- 2008/3/13

(1)

POSITIVE RECALL

EFFECTIVE 01/21 AUTH

RELEASED _____ DATE _____

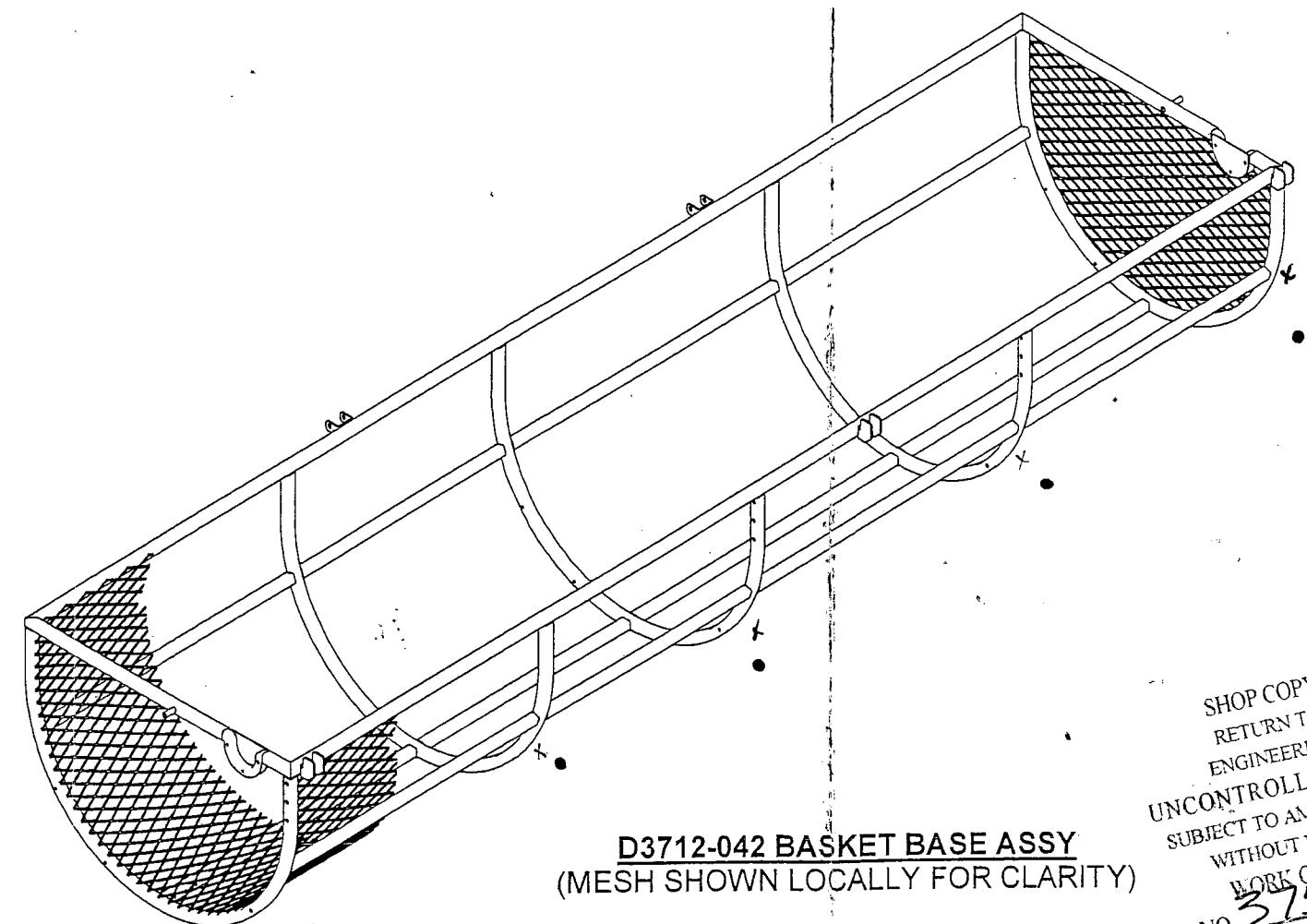
W/O:		WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY. -041	PART NUMBER	DESCRIPTION
X	D3712-042	BASKET BASE ASSY
2	D2327-3	SPACER BUSHING
2	D2581	MOUNTING BRACKET
2	D3725-1	HOOP
2	D3726-1	RIB
2	D3727-1	RIB
2	D3734-1	RIB
5	D3735-1	RIB
1	D3735-3	RIB
3	D3739-1	RIB
3	D3740-1	RIB
1	D3744-1	MESH
1	D3745-1	MESH
1	D3745-3	MESH
1	D3746-1	RIB
1	D3746-3	RIB
2	D3746-5	RIB
1	D3746-7	RIB
3	D3748-1	HINGE HALF
2	D3757-1	BLANKING PLATE
6	AN3-10A	BOLT
12	AN960JD10	WASHER
6	MS21042L3	NUT



D3712-042 BASKET BASE ASSY
(MESH SHOWN LOCALLY FOR CLARITY)

SHOP COPY
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WITHOUT NOTICE
WORK ORDER
NO. 37525

PRELIMINARY ISSUE

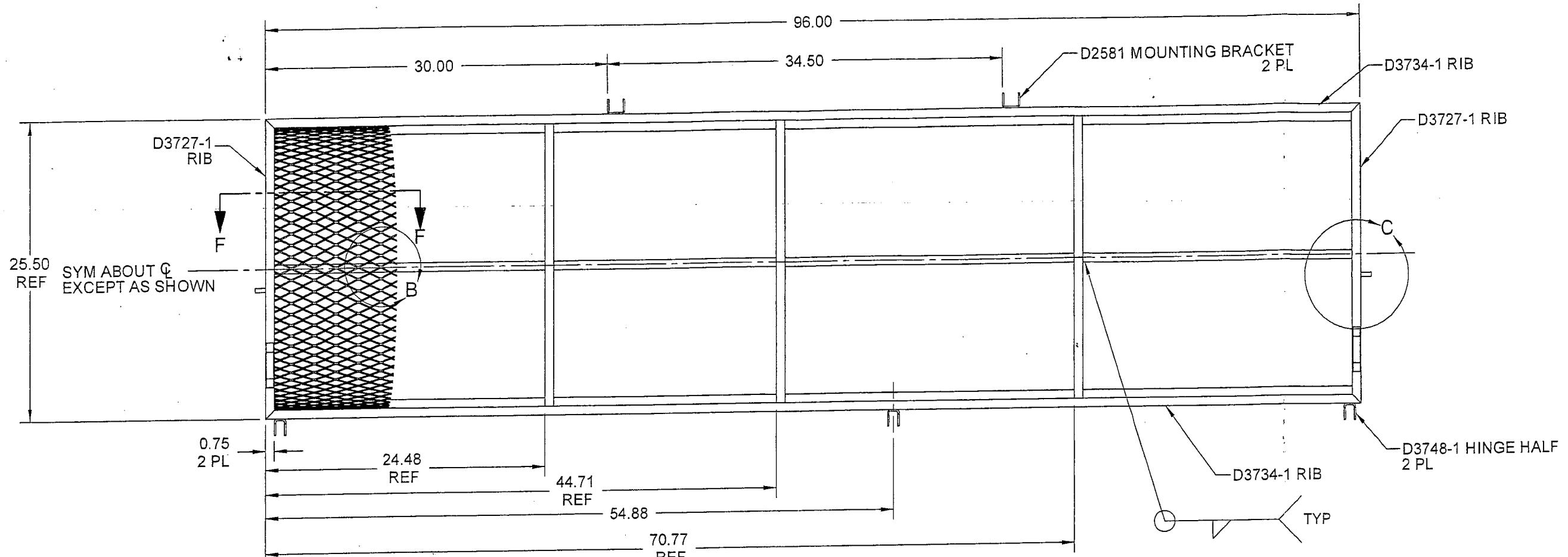
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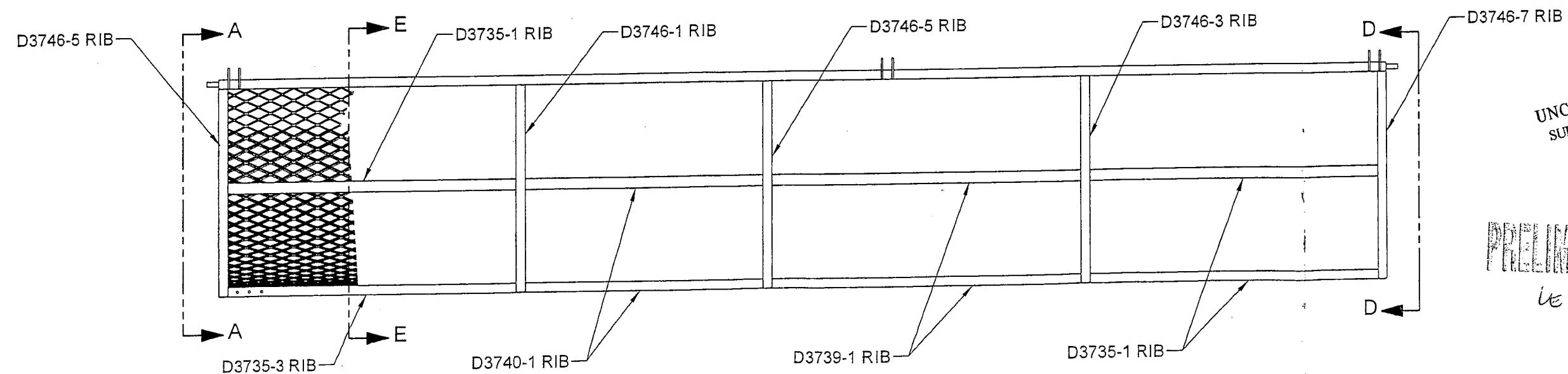
- 1) MATERIAL: NONE
- 2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 41.53 lbs
- 8) WELDING: PER DART QSI 004

A	NEW ISSUE	AJS	08.01.29
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	IC	DRAWING NO.	REV. A
MFG. APPR.		D3712	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.	IC	BASKET BASE ASSY	NTS
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(MESH SHOWN LOCALLY FOR CLARITY)



D3712-041 BASKET BASE ASSY

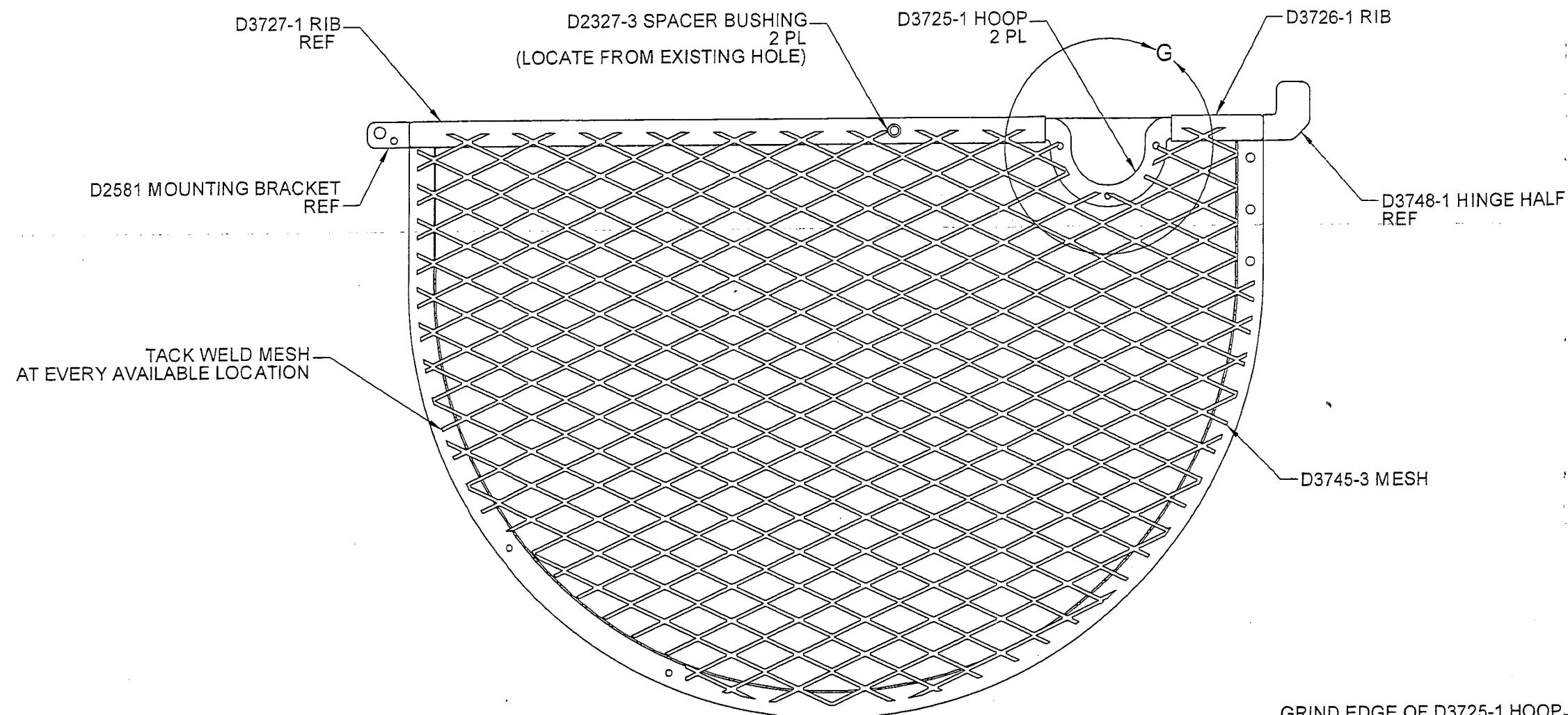
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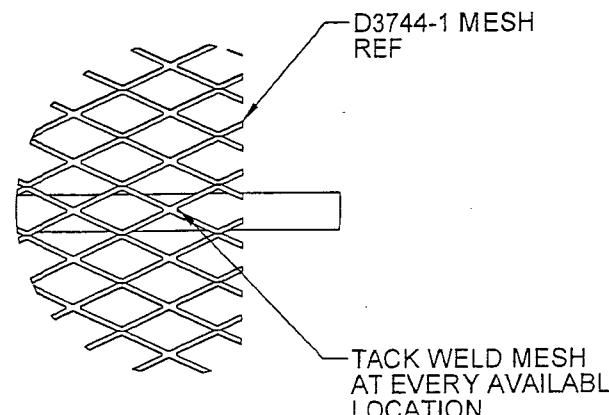
IE 08-02-15

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>JK</i>	DRAWING NO.	
MFG. APPR.		D3712	REV. A
APPROVED		TITLE	SHEET 2 OF 4
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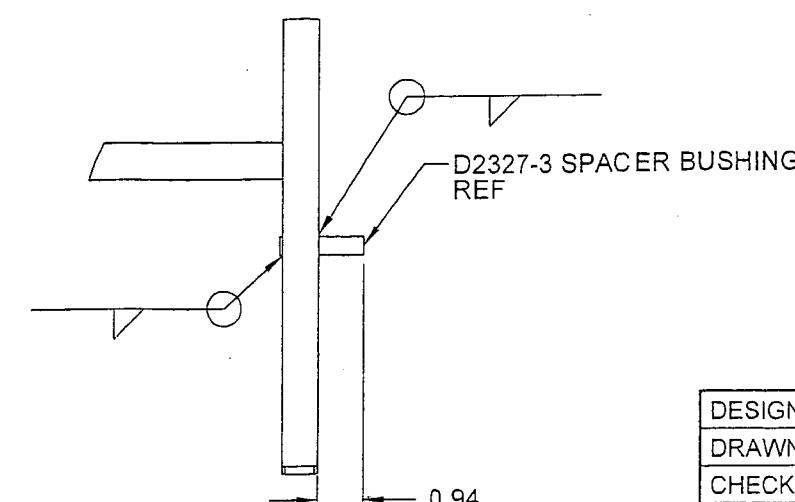
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SECTION A-A
SCALE 1:4

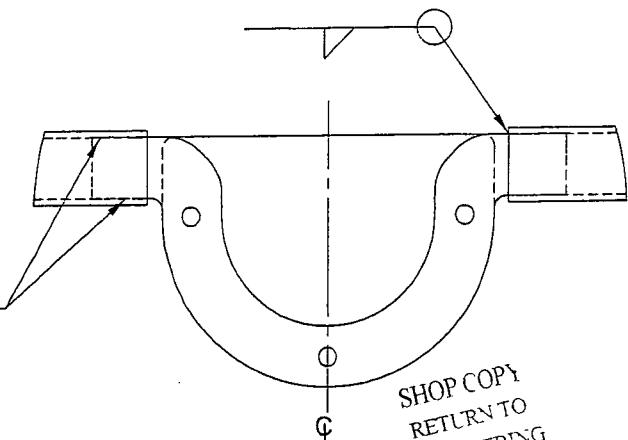


DETAIL B
SCALE 1:4



DETAIL C
SCALE 1:4

GRIND EDGE OF D3725-1 HOOP
LOCALLY AS REQUIRED
ON ASSEMBLY

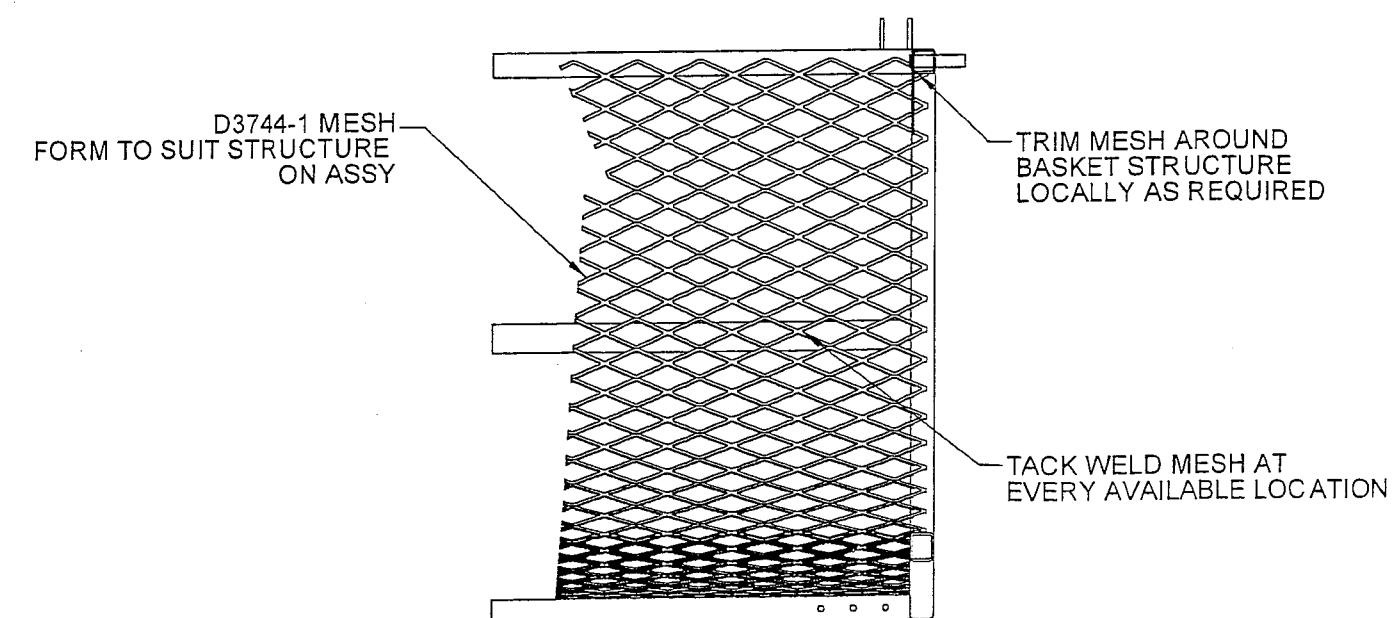
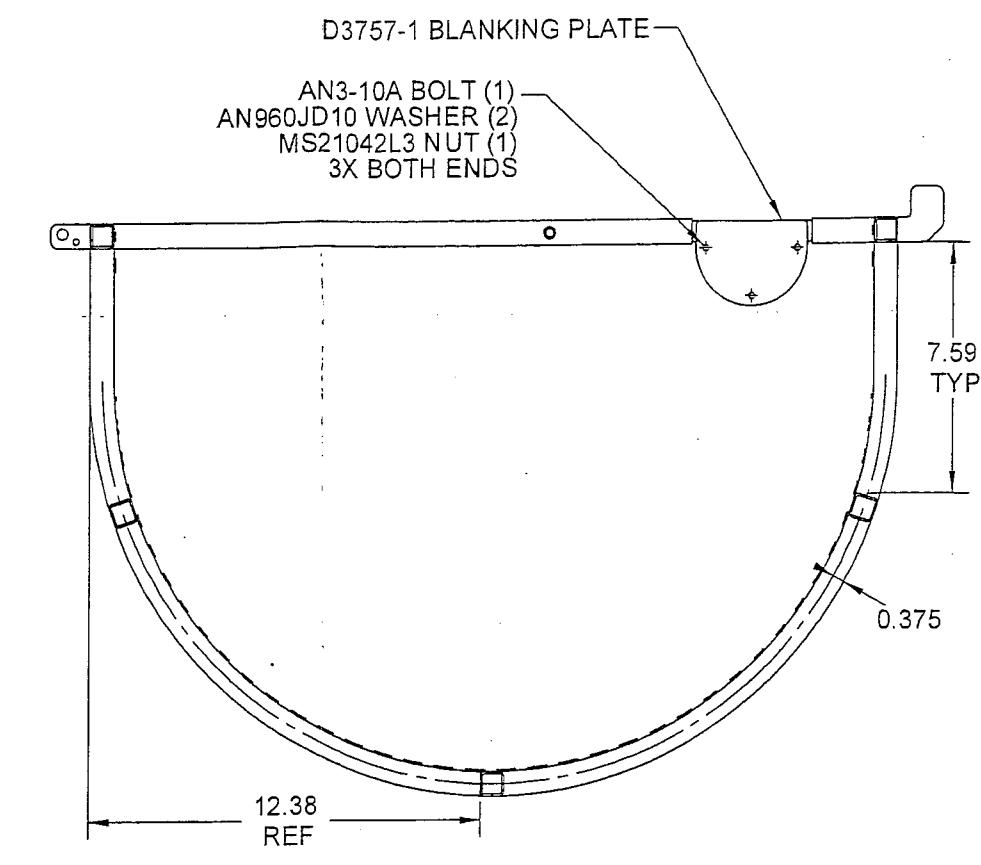
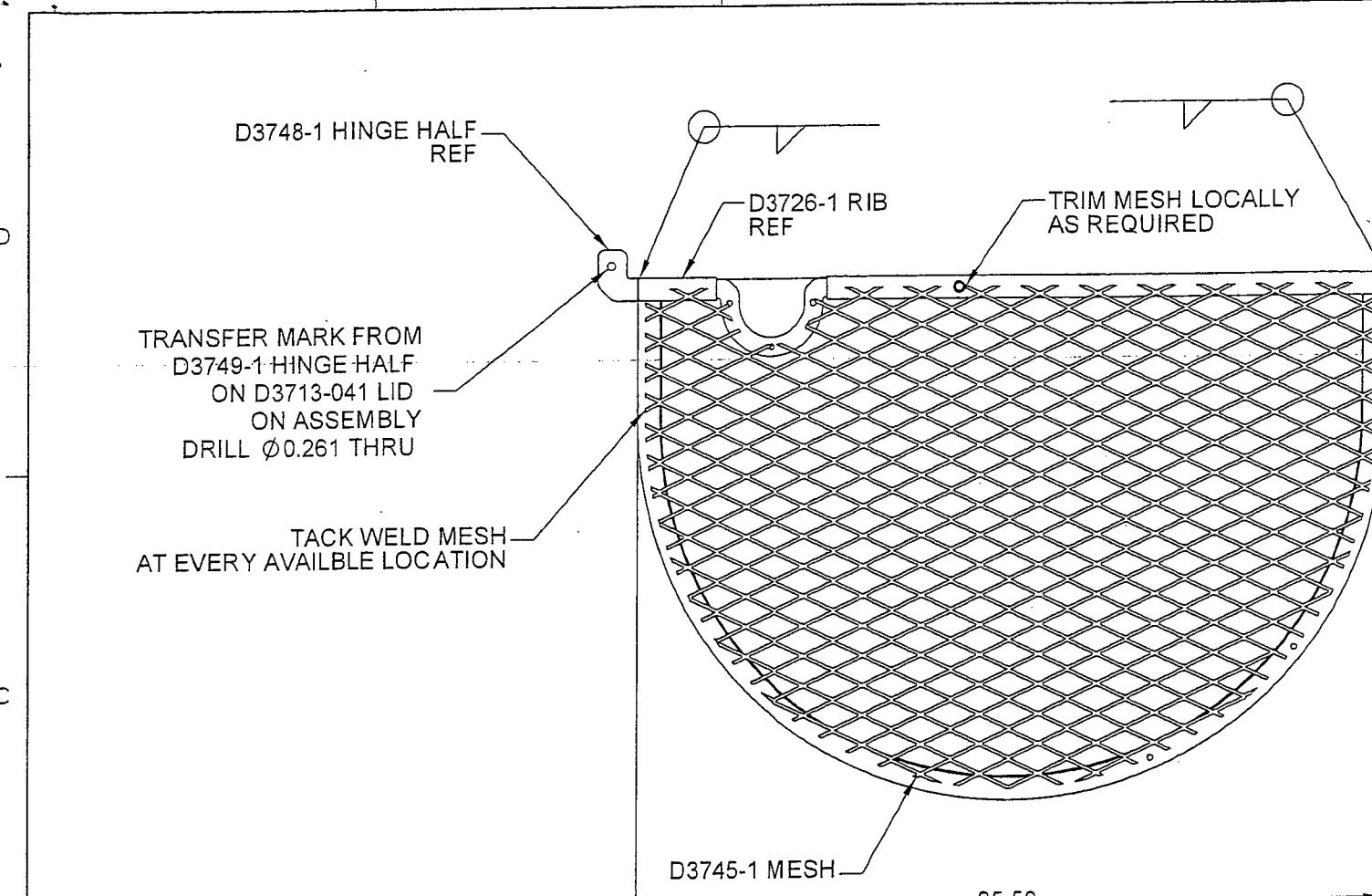


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DE APPR.	#	SHEET 3 OF 4
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CHECKED	UE	DRAWING NO.	D3712
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APPROVED		TITLE	BASKET BASE ASSY
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